

07-21-00

A

07/20/00
JC853 U.S. PTO
A L I G N

invisalign

JC877 U.S. PTO
09/620253
07/20/00

July 20, 2000

Box Patent Application
Commissioner for Patents
Washington, DC 20231

Presented for filing is a new original patent application of:

Applicant: BARRY A. SIMKINS

Title: SYSTEMS AND METHODS FOR MASS CUSTOMIZATION

Enclosed are the following papers, including those required to receive a filing date under 37 CFR 1.53(b):

	<u>Pages</u>
Specification	15
Claims	3
Abstract	1
Drawing(s)	8
Declaration	1

Enclosures:

Check for \$708 (filing fee plus fee for one claim over 20) and postcard.

If this application is found to be incomplete, or if a telephone conference would otherwise be helpful, please call the undersigned at (408) 738.7243.

Kindly acknowledge receipt of this application by returning the enclosed postcard.

Please send all correspondence to:

Bao Tran
Align Technology, Inc.
442 Potrero Avenue
Sunnyvale, CA 94086

Respectfully submitted,



Bao Q. Tran
Reg. No. 37,955
Enclosures

APPLICATION FOR UNITED STATES PATENT

in the name of

BARRY A. SIMKINS

of

Align Technologies, Inc.

for

**SYSTEMS AND METHODS FOR MASS
CUSTOMIZATION**

Bao Q. Tran
Align Technology, Inc.
442 Potrero Avenue
Sunnyvale, California 94086
Tel.: 408.738.7267
Fax: 408.738.7150

DOCKET NO.:

AT00082

DATE OF DEPOSIT:

20 July 2000

EXPRESS MAIL NO.:

EK 628677067 **US**

Systems and Methods for Mass Customization

BACKGROUND

5

This invention relates to systems and methods for mass customization.

Mass customization is the application of mass production techniques to the production of parts that are different from each other and produced in rapid sequence. Mass-producing items that are generically similar to each other using production
10 equipment that is rapidly modifiable or reprogrammable allows differences between these items. Typical limitations on the variability of product are inherent in the design of the manufacturing equipment; as an example, shoe-making machinery would not likely produce cars. Within limits, shoe-making machinery (for example) might produce different sizes, widths and even styles of shoes; this is possible with computer-controlled,
15 automatic machinery. Such mass customization uses computer aided manufacturing (CAM) data that specifies process operations for each unique part.

Mass customization is especially suited for producing items that are based on, or made to work with organic forms. Organic, or natural shapes include plant and animal forms. Each of these forms is often a variation on a theme, either as a species or as an
20 anatomical part. Typically moderate variations, in each organic category, are manageable by the adaptability of mass customization in making products to fit these forms. Examples of such products include apparel, surgical implants and prosthetic devices. The basic form of any of these products is common enough to be produced parametrically. Specific data, for each item produced, is entered into a table or template. The template
25 represents the generic description, and the data entered into the template represents the specific description of the product.

Material removal or modification machinery is often controlled by a CAM program that requires specific information to define the geometry of the affected operation, the tool orientation, and the part being modified. Certain CAM programs
30 automatically determine the entire machine operation mostly based on the desired final shape or condition of the part. Complex shapes, such as organic forms, generate very large descriptions of geometry in computerized formats, so CAM calculations are commensurately extensive for these shapes. These CAM calculations use surface

geometry for tool orientation because material removal and modification are dependent on orientation of the tool axis in reference to the local surface. Also, surface transitions between convex and concave forms cause undulation of the tool and its motion system, when current CAM control is used. This complex mechanism motion is subject to
5 accelerations that are limited by motor capacity and system stiffness, resulting in forces that cause wear; so accelerations are kept to moderate levels. Regulation of accelerations limits the average mechanism speed, an undesirable effect for rapid process execution. This process can be optimized by eliminating unnecessary accelerations by streamlining the path of mechanism motion.

10 CAM data flow and calculation speed are limited by file size, and tool progression speed is limited by undulation; so this whole process is very dependent on geometric complexity. CAM controlled machines operate at sub-optimal speed when they use organic surface geometry as a reference. For example, conventional CAM systems use surface data to define a toolpath, therefore, tool orientation is based on surface normals.
15 Conventionally, the tool orientation will change radically to accommodate undulations that are prevalent in complex (organic) geometry, and this will require the tool head to move forward and backward along the toolpath, and generally to change direction erratically. This erratic motion is wasted motion, and it requires substantial positive & negative accelerations of the tool head.

SUMMARY

In one aspect, a method facilitates mass customization of an object having an ideal model surface by generating a template representing data common to the object; generating specific data to customize the object in conjunction with the template; and
25 fabricating a customized version of the object.

Implementations of the above aspect may include one or more of the following. The method includes generating a tool-path to customize the object. The target path may be represented as a spline. The method includes creating an idealized tool-path from the ideal model surface. A mathematically smooth 3D spline using the idealized toolpath can
30 be generated. The method includes generating surface normals from the ideal model surface at points distributed around the idealized toolpath. Each surface normal can be

displaced from its end to the nearest point on the smooth 3D spline. A spline can be created for connecting each unattached end of each surface normal. The ends are attached sequentially in a loop. A source spline can be used to define motion of the tool head by defining tool orientation vectors, and subsequent motion of a tool head. The source spline can be adjusted, such as by moderate elevation or lowering of the angle of the surface normal.

In another aspect, a method fabricates an object having an ideal model surface by receiving a digital representation of a target path; generating a mathematically smoothed version of the target path; applying the smoothed target path as a base to generate a secondary target path; and generating a streamlined tool-path to fabricate the object.

In yet another aspect, a method optimizes data flow, CAM calculation and mechanism motion by applying a statistical concept to the creation of toolpaths.

In another aspect, a template is used to generate a toolpath for laser cutting the margins of an object.

Advantages of the invention may include one or more of the following. The techniques support rapid mass customization with rapid execution of data streaming, CAM calculations, and process device actions. The amount of data required by CAM for processing instructions to control material removal or modification machinery is reduced. The technique is advantageous for rapid workpiece changing situations that use dissimilar, but generically related shapes for workpieces and where the depth of action is not critical. Appropriate processes include cutting, surface conditioning, trimming and welding with laser, plasma torch, and water jet as well as other projection-to-surface style devices.

In addition to reducing the processing and handling of data, the techniques also streamline the motion for the trim devices. These advantages can be attributed in part to the source spline. The source spline effectively reduces data requirements by extracting common data from the calculation process, and adding it back in as a template by incorporating it into the algorithm. Motion streamlining is achieved by eliminating undulated movement of the tool head along the source spline.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is an elevational diagram showing the anatomical relationship of the jaws of a patient.

FIG. 2A illustrates in more detail the patient's lower jaw and provides a general indication of how teeth may be moved by the methods and apparatus of the present invention.

FIG. 2B illustrates a single tooth from FIG. 2A and defines how tooth movement distances are determined.

FIG. 2C illustrates the jaw of FIG. 2A together with an incremental position adjustment appliance.

FIG. 3 is a block diagram illustrating a process for producing incremental position adjustment appliances.

FIGS. 4A-4B are exemplary illustrations of trimming operations using splines.

FIG. 5 is an exemplary illustration of a smoothed 3D spline and an ideal toolpath.

FIG. 6 is a flow chart illustrating a process for smoothing splines.

FIG. 7 is a block diagram illustrating a system for generating appliances in accordance with the present invention.

DESCRIPTION

FIG. 1 shows a skull 10 with an upper jaw bone 22 and a lower jaw bone 20. The lower jaw bone 20 hinges at a joint 30 to the skull 10. The joint 30 is called a temporal mandibular joint (TMJ). The upper jaw bone 22 is associated with an upper jaw 101, while the lower jaw bone 20 is associated with a lower jaw 100. A computer model of the jaws 100 and 101 is generated in accordance with the process of FIG. 3, and a computer simulation can model interactions among the teeth on the jaws 100 and 101. The computer simulation allows the system to focus on motions involving contacts between teeth mounted on the jaws. The computer simulation allows the system to render realistic jaw movements that are physically correct when the jaws 100 and 101 contact each other. The model of the jaw places the individual teeth in a treated position. Further, the model can be used to simulate jaw movements including protrusive motions, lateral motions, and "tooth guided" motions where the path of the lower jaw 100 is

guided by teeth contacts rather than by anatomical limits of the jaws 100 and 101.

Motions are applied to one jaw, but may also be applied to both jaws. Based on the occlusion determination, the final position of the teeth can be ascertained.

Referring now to FIG. 2A, the computer model of the lower jaw 100 includes a plurality of teeth 102, for example. At least some of these teeth may be moved from an initial tooth arrangement to a final tooth arrangement. As a frame of reference describing how a tooth may be moved, an arbitrary centerline (CL) may be drawn through the tooth 102. With reference to this centerline (CL), each tooth may be moved in orthogonal directions represented by axes 104, 106, and 108 (where 104 is the centerline). The centerline may be rotated about the axis 108 (root angulation) and the axis 104 (torque) as indicated by arrows 110 and 112, respectively. Additionally, the tooth may be rotated about the centerline, as represented by an arrow 114. Thus, all possible free-form motions of the tooth can be performed.

FIG. 2B shows how the magnitude of any tooth movement may be defined in terms of a maximum linear translation of any point P on a tooth 102. Each point P1 will undergo a cumulative translation as that tooth is moved in any of the orthogonal or rotational directions defined in FIG. 2A. That is, while the point will usually follow a nonlinear path, there is a linear distance between any point in the tooth when determined at any two times during the treatment. Thus, an arbitrary point P1 may in fact undergo a true side-to-side translation as indicated by arrow d1, while a second arbitration point P2 may travel along an arcuate path, resulting in a final translation d2. Many aspects of the present invention are defined in terms of the maximum permissible movement of a point P1 induced on any particular tooth. Such maximum tooth movement, in turn, is defined as the maximum linear translation of that point P1 on the tooth that undergoes the maximum movement for that tooth in any treatment step.

FIG. 2C shows one adjustment appliance 111 which can be worn by the patient in order to achieve an incremental repositioning of individual teeth in the jaw as described generally above. The appliance is a polymeric shell having a teeth-receiving cavity, as described in U.S. Patent No. 5,975,893, entitled "Method and system for incrementally moving teeth," the full disclosures of which are incorporated by reference.

As set forth in the prior applications, each polymeric shell may be configured so that its tooth-receiving cavity has a geometry corresponding to an intermediate or final tooth arrangement intended for the appliance. The patient's teeth are repositioned from their initial tooth arrangement to a final tooth arrangement by placing a series of
5 incremental position adjustment appliances over the patient's teeth. The adjustment appliances are generated at the beginning of the treatment, and the patient wears each appliance until the pressure of each appliance on the teeth can no longer be felt. At that point, the patient replaces the current adjustment appliance with the next adjustment appliance in the series until no more appliances remain. Conveniently, the appliances are
10 generally not affixed to the teeth and the patient may place and replace the appliances at any time during the procedure.

The polymeric shell 111 can fit over all teeth present in the upper or lower jaw. Often, only certain one(s) of the teeth will be repositioned while others of the teeth will provide a base or an anchor region for holding the appliance 111 in place as the appliance
15 111 applies a resilient repositioning force against the tooth or teeth to be repositioned. In complex cases, however, multiple teeth may be repositioned at some point during the treatment. In such cases, the moved teeth can also serve as a base or anchor region for holding the repositioning appliance.

The polymeric appliance 111 of FIG. 2C may be formed from a thin sheet of a
20 suitable elastomeric polymer, such as Tru-Tain 0.03 in, thermal forming dental material, available from Tru-Tain Plastics, Rochester, Minnesota. Usually, no wires or other means will be provided for holding the appliance in place over the teeth. In some cases, however, it will be desirable or necessary to provide individual anchors on teeth with corresponding receptacles or apertures in the appliance 100 so that the appliance can
25 apply an upward force on the tooth that would not be possible in the absence of such an anchor.

FIG. 3 shows a process 200 for producing the incremental position adjustment appliances for subsequent use by a patient to reposition the patient's teeth. The flow chart of FIG. 3 is for purpose of explanation and does not necessarily reflect all possible paths
30 of control flow in the execution of the client program.

As a first step, an initial digital data set representing an initial tooth arrangement is obtained (step 202). The initial data set may be obtained in a variety of ways. For example, the patient's teeth may be scanned or imaged using X-rays, three dimensional X-rays, computer-aided tomographic images or data sets, or magnetic resonance images, among others. The teeth data may be generated by a destructive scanner, as described in the incorporated-by-reference U.S. Application Serial No. 09/169,034, filed October 8, 1998. The initial data set is then manipulated using a computer having a suitable graphical user interface (GUI) and software appropriate for viewing and modifying the images. More specific aspects of this process will be described in detail below.

Individual tooth and other components may be segmented or isolated in the model to permit their individual repositioning or removal from the digital model.

After segmenting or isolating the components, the teeth are moved based on rules and algorithms programmed into the computer. In this step, each stage of tooth movement is determined by an attraction model between selected points on adjacent teeth. This step is iterated until an acceptable result is achieved (step 206). In one embodiment, the system stops the movement when the relative positions of the teeth satisfy a predetermined target.

In step 206, positions for the upper and lower teeth in a masticatory system of a patient are determined by generating a computer representation of the masticatory system. An occlusion of the upper and lower teeth is computed from the computer representation; and a functional occlusion is computed based on interactions in the computer representation of the masticatory system. The occlusion may be determined by generating a set of ideal models of the teeth. Each ideal model in the set of ideal models is an abstract model of idealized teeth placement, which is customized to the patient's teeth, as discussed below. After applying the ideal model to the computer representation, the position of the teeth can be optimized to fit the ideal model. The ideal model may be specified by one or more arch forms, or may be specified using various features associated with the teeth.

Once the teeth arrangements are determined, a series of appliances that move the teeth in a specified sequence are generated (step 208). For example, the teeth models may be rotated until their roots are in the proper vertical position. Next, the teeth models

may be rotated around their vertical axis into the proper orientation. The teeth models are then observed from the side, and translated vertically into their proper vertical position. Finally, the two arches are placed together, and the teeth models moved slightly to ensure that the upper and lower arches properly mesh together. The meshing of the upper and lower arches together can be visualized using a collision detection process to highlight the contacting points of the teeth.

During manufacturing, the appliances need to be cut or trimmed. The processes described below generate toolpaths from geometric input to define automated motion of a computer-controlled device to trim objects such as appliances. The application of this technique is more appropriate for complex, three-dimensional solid or surface geometry, both in reference to the toolpath and to the basic shape used to create the toolpath (i.e., the workpiece). However, the techniques can be applied to two-dimensional geometry as well.

FIGS. 4A, 4B, 5 and 6 show embodiments applied to defined automated motion of a computer-controlled device to generate a physical model based on a dental arch. FIG. 4A shows a ribbon 400 surrounding an object 402. In this embodiment, the object 402 is a model of a dental arch of teeth. The ribbon 400 represents a toolpath for a trimming operation, and the teeth model represents complex geometry that the toolpath is specifically generated for. The top edge of this ribbon 400 is a template or source spline 404 that is common to all toolpaths, whereas the bottom edge is the target spline, unique to each file that is downloaded to the CAM system. The template is a parametric table or form that can be customized to a specific object.

Information required to control the trim motion is contained in one or more ribbon components, including the source spline or template 404, a target spline 406, synchronization points 410 on the source spline or template 404, and target points 408 on the target spline 406. The ribbon surface and synchronization lines may be inferred from spline data and synchronization data.

The source spline 404 works in conjunction with the target spline 406. A physical or geometric relationship exists between the source spline 404 and the target spline 406 that defines a surface swept between the source spline 404 and the target spline 406. The geometric relationship is expressed as the tool path and represents the vectors for the tool.

Exemplary vectors include the perimeter of a rotary tool such as a milling cutter or the center line of a beam of light from a laser or a beam of fluid from a water jet cutter.

During processing, synchronization lines 412 are projected from the synchronization point 410 to target point 408. The synchronization point 410 can be pre-established in position on the source spline or template 404. The target point 408 that correlates with the synchronization point 410 should be positioned on the target spline 406. In one embodiment, an orthogonal or plan view of FIG. 4A can be used to generate orientations for synchronization lines 412 that appear as surface normals to the target spline 406. The direction for each projection is from the source spline (404) to the target spline (406) and represents the equivalent of surface normals to the smoothed target spline 452 (mathematically smoothed 3D spline). The projection is done such that the synchronization lines 412 are substantially orthogonal to the mathematically smooth spline 452. The length of the surface normals is adjustable. Long normals tend to resemble the average more than short normals since angular changes from specific target splines change more radically with angular changes for short normals. Short normals tend to provide high resolution at the expense of more data having to flow through the CAM system. Alternatively, long normals would provide faster motion at the expense of precision and resolution because the angular changes have to be accurately controlled.

The template takes common information required for the CAM process as a standard for all cases in mass customization. By applying a relatively simple set of data that represents the differences between all of the different parts, the template 404 can be adapted for each object 402 to customize the output. The information embodied in the template may be streamlined. One optimization removes CAM calculations that are based on specific solid geometry from the toolpath generation process. In such an optimization, surface undulations are ignored. The optimization of tool head velocity can be achieved by minimizing the number, magnitudes and durations of accelerations because these parameters have deleterious effect on average velocity. The template minimizes these degradations of toolpath motions by ignoring their source.

In one embodiment, one or more generic files are categorized so that similar shapes are defined within parametric limits such as size or shape within a superset; for example, small dental arches are distinguished from large arches. In one implementation,

code can be provided in the file for calling the template 404. In another embodiment, a hierarchical format is used to enhance the adaptability of CAM to fit a wide range of shapes that a specific process would be applied to; for example, modification of bone implants for different types of bones. The source spline shape and other parametric data
5 can be grouped under headings or subheadings.

FIG. 4B is another view of FIG. 4A. FIG. 4B shows the object 402 resting on a support 430. FIG. 4B also shows a smooth path 432 for the motion of the system of the laser 404. In the exemplary embodiment of FIG. 4B, trim vectors 420 are approximately forty degrees relative to object surface normals. The object 402 bears a generalized
10 relationship to the surface normals so that the angle is constant in this example. The surface normals of FIG. 4B follow a predetermined formula that is based on an idealized model of the object 402.

The motion system of FIGS. 4A and 4B follows the tool path has a motion that is generally smooth and constantly leading. As the motion system follows the source spline
15 404 or an equivalent of the source spline 404, its motion is smooth. Further, any vectors that relate to a position at any moment in time of the motion system at 404 as it moves forward also relates to a forward motion along the target spline (408). Thus, a correlated move generally exists in the forward direction between the motion system and the target object itself.

FIG. 5 shows in more detail the relationship between an idealized tool-path 450 and a mathematically smoothed spline 452. A transition or translation process mathematically converts the idealized tool path 450 into a spline 452 that is a mathematically smoothed 3D spline. The mathematically smoothed spline generally follows a monotonic curvature in all three dimensions. The mathematically smoothed 3D
25 spline is used in an intermediate step that generates a set of synchronization lines which are all the same length and which have been adjusted specifically so that the other ends of the synchronization line are connectable together by another 3D spline that becomes a source spline. The mathematically smoothed spline is provided to a CNC controller that generates a smooth tool path and drives the tool head motion itself. An end-effector of
30 the tool can articulate around the target object using a numerically controlled (NC) axis or rotary axis that changes the vector from any given points along the source spline 404.

In FIG. 5, synchronization lines 412 that descend from the top spline to the bottom spline are representative of the direction (vector) of the trim beam or tool axis at different positions around the path. The CAM interpolates the toolpath between synchronization lines. Due to the interpolation, the resulting motion of the source device (laser motion devices) is smooth and progressive without sharp turns or reversals. In embodiments where the source device is a laser or projected beam device where effective focus occurs with substantial focal depth, the source device does not need to track the target along the axis of the trim beam, even though the target spline articulates in this beam-axis direction.

FIG. 6 shows a process 450 to generate a smoothed spline for trimming an object. The smoothing of a spline such as a source spline first requires the creation of an ideal model surface or solid shape (step 452). In an embodiment, the ideal model surface or shape can be a 3D statistical mean. In another embodiment, the ideal surface or solid shape may represent all individual models, a dental arch in this example. After this ideal model is created, the process 450 creates an idealized toolpath (step 454). The idealized toolpath can consist of a 3D spline that is anchored to the surface of the model. This toolpath may follow a surface feature such as the gum line of this dental model, or follow a design feature. Next, the process 450 generates a (mathematically) smooth 3D spline using the idealized toolpath (equivalent to the target spline) from the ideal model surface (step 456). The process 450 then generates surface normals from the ideal model surface at points distributed around the idealized toolpath (step 458). These surface normals should be the same length, preferably matching the distance from the closest rotary axis of the motion system. Elevate or lower these normals by a consistent angle, if required; the example shows 40-degree elevation. The process 450 then displaces each surface normal from its end to the nearest point on the smooth 3D spline (step 460). Step 460 displaces the surface normals from the idealized spline which is rather curvy into the mathematically smoothed 3D spline to create a set of surface normals or synchronization lines that have an angular relationship to the surface normals. The endpoints are connectable with the smooth spline that then in turn creates the source spline.

A spline is created that connects each unattached end of all the surface normals sequentially in a loop (step 462). This spline will be the source spline that will define

motion of the tool head by defining tool orientation vectors, and subsequent motion of the tool head itself. If this source spline is not smooth, it may be adjusted (step 464). In one embodiment, the adjustment includes a moderate elevation or lowering of the angle of each surface normal using the target spline intersection as a pivot axis, and alteration of the source spline. This adjustment will beneficially affect streamlining of the tool head motion and action of the tool on the surface of the workpiece.

The smoothed spline generated using the process 450 is then used to cut or trim the object. The source spline data is loaded as part of a template of a computer aided manufacturing (CAM) system. This makes the CAM system capable of accepting specific target spline data as a complement that fulfills most data requirements needed to generate a specific toolpath. The template can include data requirements, and part orientation information for fixturing the workpiece must be included in the template to assure the correlation of geometry between the device toolpath and the workpiece during operation. Part orientation is established with a three-axis Cartesian datum that is common between the ideal model and all specific models. Additional common data incorporated in the template may include other process parameters such as motion velocities, effector power (flow rate, flow velocity, focus, etc.), temperature, and pulse rate. The template can also include algorithms for adjustment of process parameters that are triggered by special geometric conditions of the target spline or by special notation attached to the target spline file.

The target spline data is also loaded into the CAM system to generate coded instructions for the motion controller. This data describes the 3D spline and its reference datum. Additional information may be added for assisting control through the CAM program in a manner that distinguishes the specific file model from the ideal model, including part querying and verification of a match through machine vision or other similar means.

FIG. 6 is a simplified block diagram of a data processing system 500 for handling CAM operations. Data processing system 500 typically includes at least one processor 502 that communicates with a number of peripheral devices over bus subsystem 504. These peripheral devices typically include a storage subsystem 506 (volatile memory subsystem 508 and file storage subsystem 514), a set of user interface input and output

devices 518, and an interface to outside networks 516, including the public switched telephone network. This interface is shown schematically as "Modems and Network Interface" block 516, and is coupled to corresponding interface devices in other data processing systems over communication network interface 524. Data processing system

- 5 500 may include a terminal or a low-end personal computer or a high-end personal computer, workstation or mainframe. The user interface input devices typically include a keyboard and may further include a pointing device and a scanner. The pointing device may be an indirect pointing device such as a mouse, trackball, touchpad, or graphics tablet, or a direct pointing device such as a touchscreen incorporated into the display.
- 10 Other types of user interface input devices, such as voice recognition systems, may be used. User interface output devices may include a printer and a display subsystem, which includes a display controller and a display device coupled to the controller. The display device may be a cathode ray tube (CRT), a flat-panel device such as a liquid crystal display (LCD), or a projection device. The display subsystem may also provide nonvisual
- 15 display such as audio output.

- Storage subsystem 506 maintains the basic programming and data constructs that provide the functionality of the present invention. The software modules discussed above are typically stored in storage subsystem 506. Storage subsystem 506 typically comprises memory subsystem 508 and file storage subsystem 514. Memory subsystem 508
- 20 typically includes a number of memories including a main random access memory (RAM) 510 for storage of instructions and data during program execution and a read only memory (ROM) 512 in which fixed instructions are stored. In the case of Macintosh-compatible personal computers the ROM would include portions of the operating system; in the case of IBM-compatible personal computers, this would include
- 25 the BIOS (basic input/output system). File storage subsystem 514 provides persistent (nonvolatile) storage for program and data files, and typically includes at least one hard disk drive and at least one floppy disk drive (with associated removable media). There may also be other devices such as a CD-ROM drive and optical drives (all with their associated removable media). Additionally, the system may include drives of the type
- 30 with removable media cartridges. The removable media cartridges may, for example be hard disk cartridges, such as those marketed by Syquest and others, and flexible disk

cartridges, such as those marketed by Iomega. One or more of the drives may be located at a remote location, such as in a server on a local area network or at a site on the Internet's World Wide Web. In this context, the term "bus subsystem" is used generically so as to include any mechanism for letting the various components and subsystems communicate with each other as intended. With the exception of the input devices and the display, the other components need not be at the same physical location. Thus, for example, portions of the file storage system could be connected over various local-area or wide-area network media, including telephone lines. Similarly, the input devices and display need not be at the same location as the processor, although it is anticipated that the present invention will most often be implemented in the context of PCS and workstations. Bus subsystem 504 is shown schematically as a single bus, but a typical system has a number of buses such as a local bus and one or more expansion buses (e.g., ADB, SCSI, ISA, EISA, MCA, NuBus, or PCI), as well as serial and parallel ports. Network connections are usually established through a device such as a network adapter on one of these expansion buses or a modem on a serial port. The client computer may be a desktop system or a portable system.

Scanner 520 is responsible for scanning casts of the patient's teeth obtained either from the patient or from an orthodontist and providing the scanned digital data set information to data processing system 500 for further processing. In a distributed environment, scanner 520 may be located at a remote location and communicate scanned digital data set information to data processing system 500 over network interface 524. Fabrication machine 522 fabricates dental appliances based on intermediate and final data set information received from data processing system 500. In a distributed environment, fabrication machine 522 may be located at a remote location and receive data set information from data processing system 500 over network interface 524.

The computer system 500 receives specific geometric data or in this case specific 3D spline target data and produces an output that is understandable by a controller 521. The controller 521 interprets computer code from the computer 500 into instructions for electromechanical actuators such as motors, for example. The instructions specify acceleration ramps, velocities, changes in velocities, pulse rate, the relationship between certain motions or timing sequence and the different axes. In one embodiment with five

axis, five different motors, three motors describing X, Y and Z motion and two motors describing rotary motion about two of the axes.

Various alternatives, modifications, and equivalents may be used in lieu of the above components. The commercial manifestation of the concept of templates could take
5 different forms. One form might be as an algorithm or subprogram within CAM. Another form could be as a separate program that would work with a variety of CAM programs. A third option would be as proprietary software, developed and used internally within a company. It should be noted that this invention, if patented, would have no practical enforceability outside the commercial forms. Development of software
10 within a company for application within that company cannot be controlled outside that company; this fact makes strong development of a commercial format attractive.

While the invention has been shown and described with reference to an embodiment thereof, those skilled in the art will understand that the above and other changes in form and detail may be made without departing from the spirit and scope of
15 the following claims.

What is claimed is:

1. A method for facilitating mass customization of an object, comprising:
generating a template representing data common to the object;
generating specific data to customize the object in conjunction with the template;
and
5 fabricating a customized version of the object.
2. The method of claim 1, further comprising generating a tool-path to
customize the object.
- 10 3. The method of 1, wherein the target path is represented as a spline.
4. The method of claim 1, wherein the object has an ideal model surface,
further comprising creating an idealized tool-path from the ideal model surface.
- 15 5. The method of claim 1, further comprising generating a mathematically
smooth 3D spline using the idealized toolpath.
6. The method of claim 1, further comprising generating surface normals
from the ideal model surface at points distributed around the idealized toolpath.
- 20 7. The method of claim 1, further comprising displacing each surface normal
from its end to the nearest point on the smooth 3D spline.
8. The method of claim 1, further comprising creating a spline connecting
25 each unattached end of each surface normal.
9. The method of claim 8, wherein the ends are attached sequentially in a
loop.

10. The method of claim 1, further comprising using a source spline to define motion of the tool head by defining tool orientation vectors, and subsequent motion of a tool head.
- 5 11. The method of claim 1, further comprising adjusting the source spline.
12. The method of claim 11, wherein the source spline is adjusted by moderate elevation or lowering of the angle of the surface normal.
- 10 13. A method for fabricating an object, comprising:
receiving a digital representation of a target path;
generating a mathematically smoothed version of the target path;
applying the smoothed target path to generate a secondary target path; and
generating a streamlined tool-path to fabricate the object.
- 15 14. The method of 13, wherein the target path is represented as a spline.
15. The method of claim 13, wherein the object has an ideal model surface, further comprising creating an idealized toolpath from the ideal model surface.
- 20 16. The method of claim 13, further comprising generating a mathematically smooth 3D spline using the idealized toolpath.
17. The method of claim 13, wherein the object has an ideal model surface,
25 further comprising generating surface normals from the ideal model surface at points distributed around the idealized toolpath.
18. The method of claim 13, further comprising displacing each surface normal from its end to the nearest point on the smooth 3D spline.

30

19. The method of claim 13, further comprising creating a spline that connects each unattached end of each surface normal and wherein the ends are attached sequentially in a loop.

5 20. The method of claim 13, further comprising using a source spline to define motion of the tool head by defining tool orientation vectors, and subsequent motion of a tool head.

21. The method of claim 13, further comprising adjusting the source spline by
10 moderate elevation or lowering of the angle of the surface normal.

11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65
66
67
68
69
70
71
72
73
74
75
76
77
78
79
80
81
82
83
84
85
86
87
88
89
90
91
92
93
94
95
96
97
98
99
100
101
102
103
104
105
106
107
108
109
110
111
112
113
114
115
116
117
118
119
120
121
122
123
124
125
126
127
128
129
130
131
132
133
134
135
136
137
138
139
140
141
142
143
144
145
146
147
148
149
150
151
152
153
154
155
156
157
158
159
160
161
162
163
164
165
166
167
168
169
170
171
172
173
174
175
176
177
178
179
180
181
182
183
184
185
186
187
188
189
190
191
192
193
194
195
196
197
198
199
200
201
202
203
204
205
206
207
208
209
210
211
212
213
214
215
216
217
218
219
220
221
222
223
224
225
226
227
228
229
230
231
232
233
234
235
236
237
238
239
240
241
242
243
244
245
246
247
248
249
250
251
252
253
254
255
256
257
258
259
260
261
262
263
264
265
266
267
268
269
270
271
272
273
274
275
276
277
278
279
280
281
282
283
284
285
286
287
288
289
290
291
292
293
294
295
296
297
298
299
300
301
302
303
304
305
306
307
308
309
310
311
312
313
314
315
316
317
318
319
320
321
322
323
324
325
326
327
328
329
330
331
332
333
334
335
336
337
338
339
340
341
342
343
344
345
346
347
348
349
350
351
352
353
354
355
356
357
358
359
360
361
362
363
364
365
366
367
368
369
370
371
372
373
374
375
376
377
378
379
380
381
382
383
384
385
386
387
388
389
390
391
392
393
394
395
396
397
398
399
400
401
402
403
404
405
406
407
408
409
410
411
412
413
414
415
416
417
418
419
420
421
422
423
424
425
426
427
428
429
430
431
432
433
434
435
436
437
438
439
440
441
442
443
444
445
446
447
448
449
450
451
452
453
454
455
456
457
458
459
460
461
462
463
464
465
466
467
468
469
470
471
472
473
474
475
476
477
478
479
480
481
482
483
484
485
486
487
488
489
490
491
492
493
494
495
496
497
498
499
500
501
502
503
504
505
506
507
508
509
510
511
512
513
514
515
516
517
518
519
520
521
522
523
524
525
526
527
528
529
530
531
532
533
534
535
536
537
538
539
540
541
542
543
544
545
546
547
548
549
550
551
552
553
554
555
556
557
558
559
560
561
562
563
564
565
566
567
568
569
570
571
572
573
574
575
576
577
578
579
580
581
582
583
584
585
586
587
588
589
590
591
592
593
594
595
596
597
598
599
600
601
602
603
604
605
606
607
608
609
610
611
612
613
614
615
616
617
618
619
620
621
622
623
624
625
626
627
628
629
630
631
632
633
634
635
636
637
638
639
640
641
642
643
644
645
646
647
648
649
650
651
652
653
654
655
656
657
658
659
660
661
662
663
664
665
666
667
668
669
670
671
672
673
674
675
676
677
678
679
680
681
682
683
684
685
686
687
688
689
690
691
692
693
694
695
696
697
698
699
700
701
702
703
704
705
706
707
708
709
710
711
712
713
714
715
716
717
718
719
720
721
722
723
724
725
726
727
728
729
730
731
732
733
734
735
736
737
738
739
740
741
742
743
744
745
746
747
748
749
750
751
752
753
754
755
756
757
758
759
760
761
762
763
764
765
766
767
768
769
770
771
772
773
774
775
776
777
778
779
780
781
782
783
784
785
786
787
788
789
790
791
792
793
794
795
796
797
798
799
800
801
802
803
804
805
806
807
808
809
810
811
812
813
814
815
816
817
818
819
820
821
822
823
824
825
826
827
828
829
830
831
832
833
834
835
836
837
838
839
840
841
842
843
844
845
846
847
848
849
850
851
852
853
854
855
856
857
858
859
860
861
862
863
864
865
866
867
868
869
870
871
872
873
874
875
876
877
878
879
880
881
882
883
884
885
886
887
888
889
890
891
892
893
894
895
896
897
898
899
900
901
902
903
904
905
906
907
908
909
910
911
912
913
914
915
916
917
918
919
920
921
922
923
924
925
926
927
928
929
930
931
932
933
934
935
936
937
938
939
940
941
942
943
944
945
946
947
948
949
950
951
952
953
954
955
956
957
958
959
960
961
962
963
964
965
966
967
968
969
970
971
972
973
974
975
976
977
978
979
980
981
982
983
984
985
986
987
988
989
990
991
992
993
994
995
996
997
998
999
1000

ABSTRACT

A method facilitates mass customization of an object by generating a template
representing data common to the object; generating specific data to customize the object
5 in conjunction with the template; and fabricating a customized version of the object.

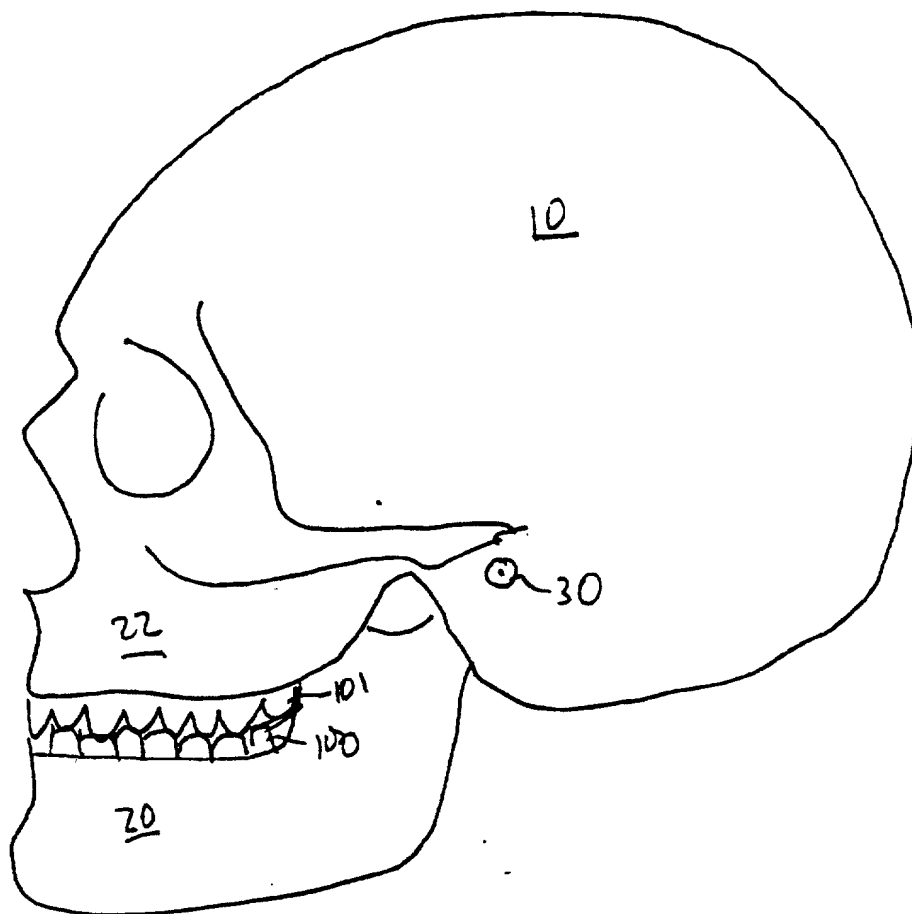


FIG. 1

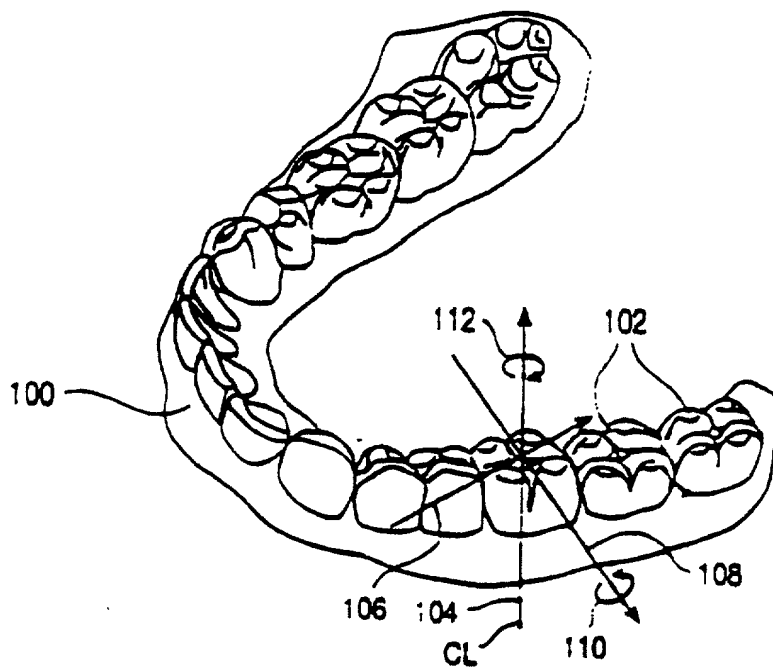


FIG. 2A

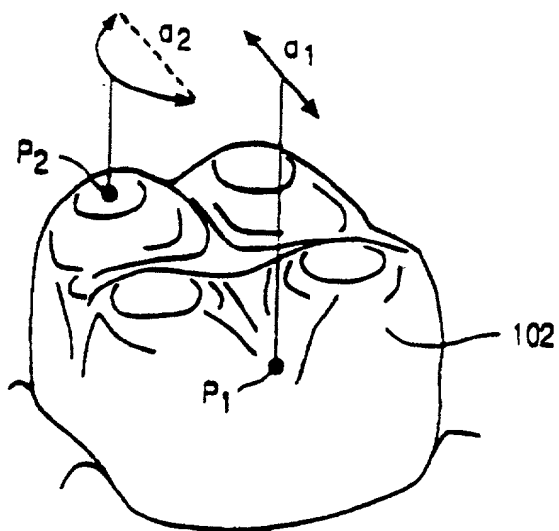


FIG. 2B

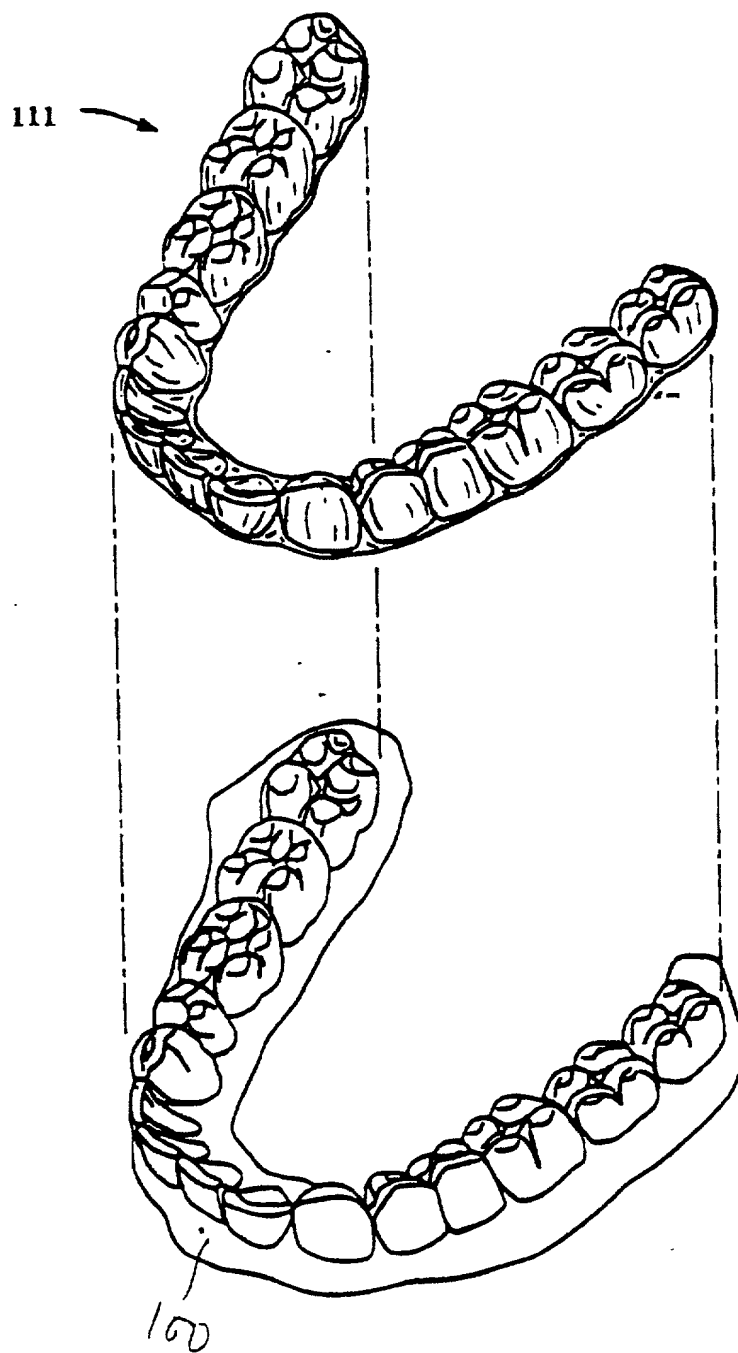


FIG. 2C

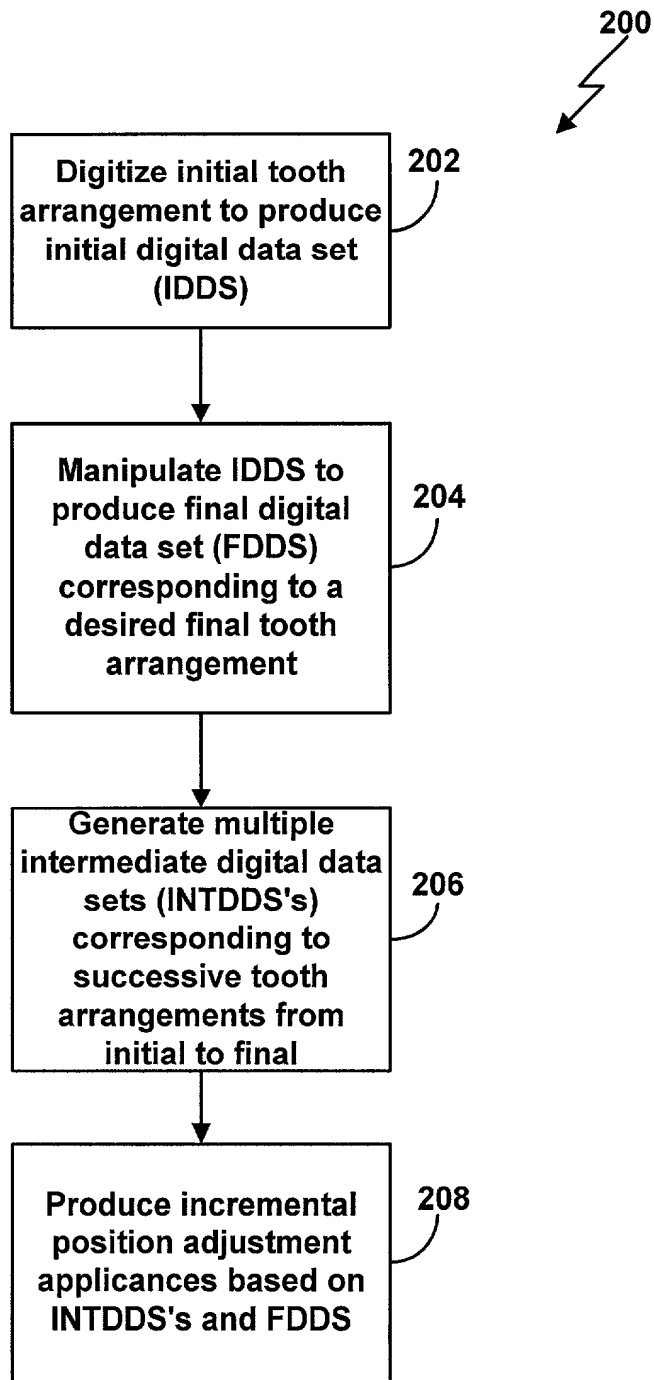


FIG. 3

FIG. 4A

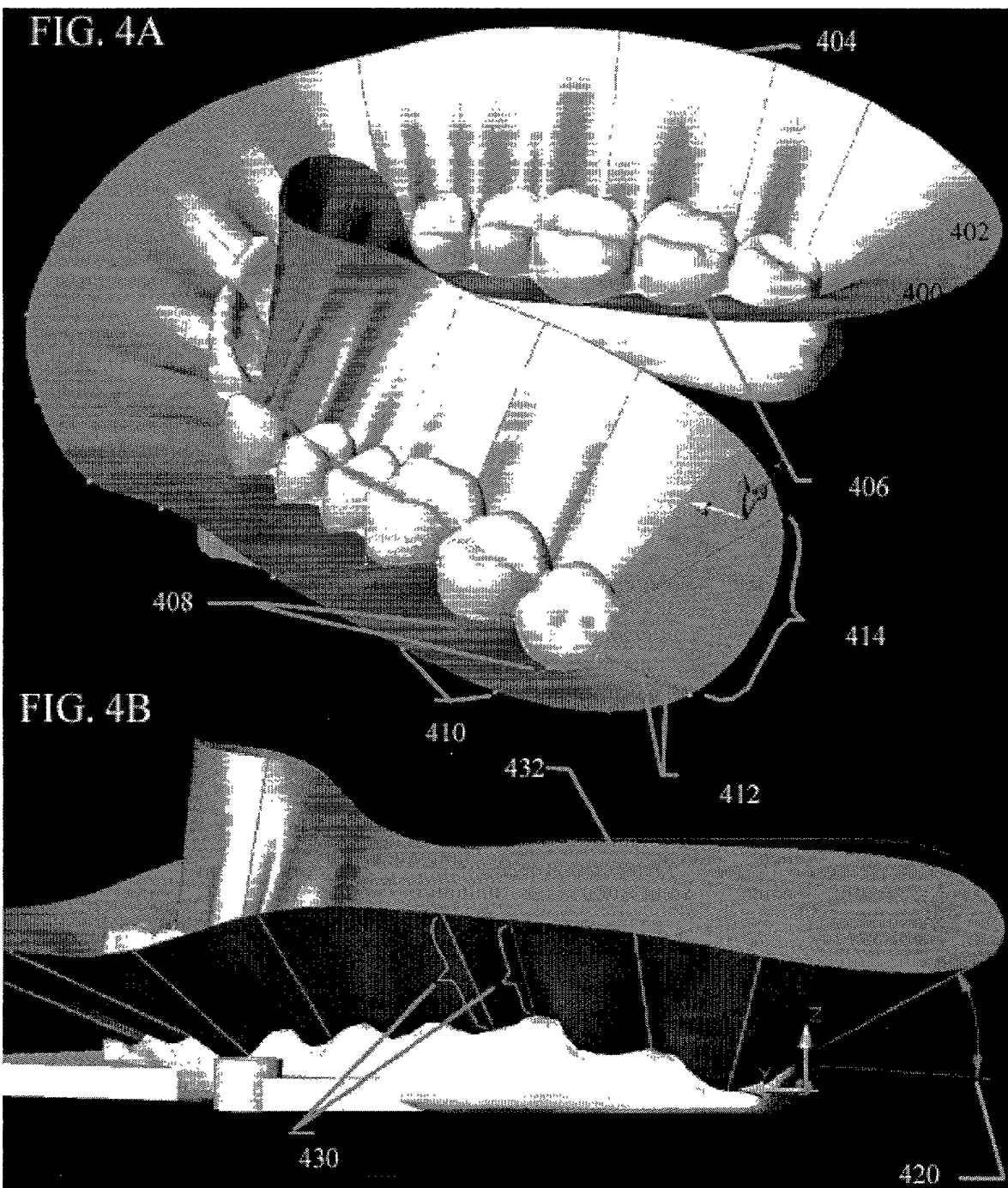
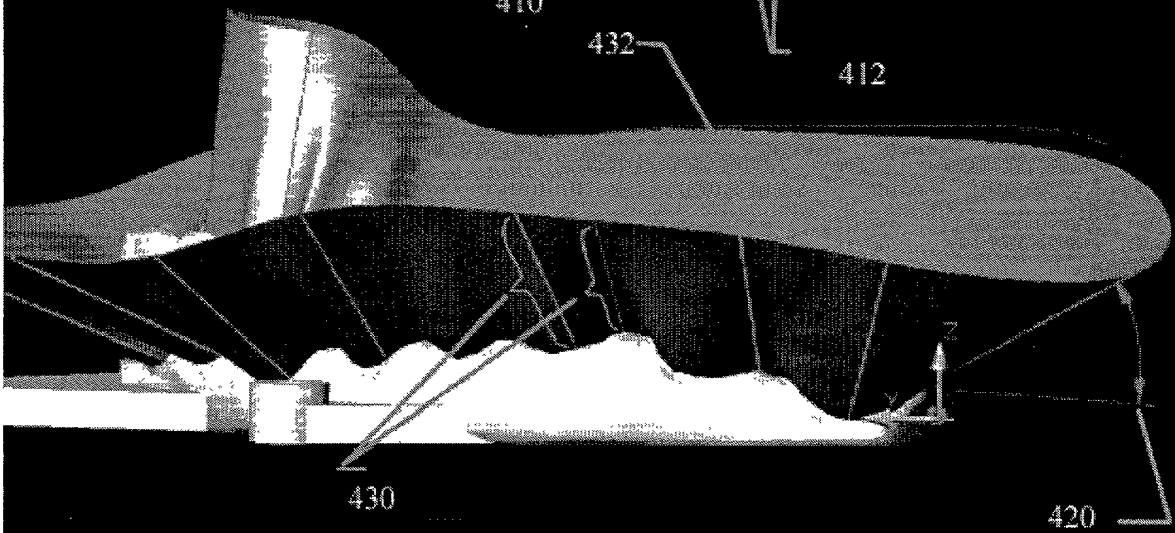
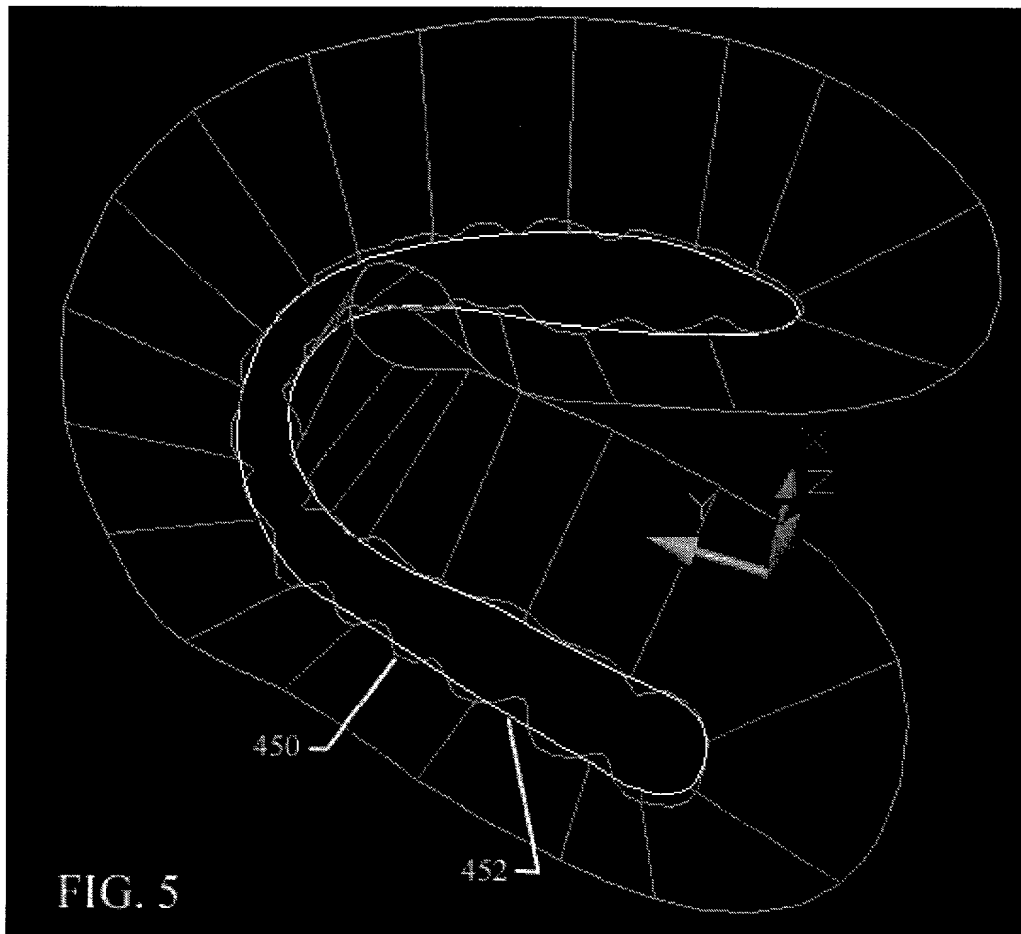


FIG. 4B





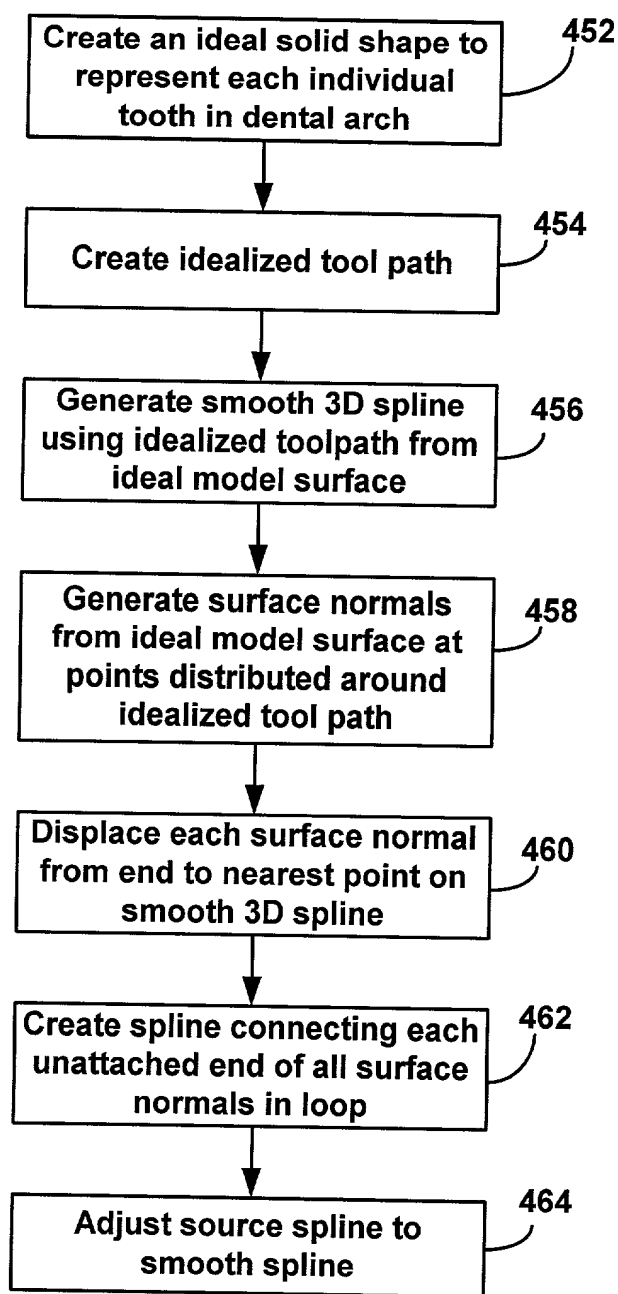


FIG. 6

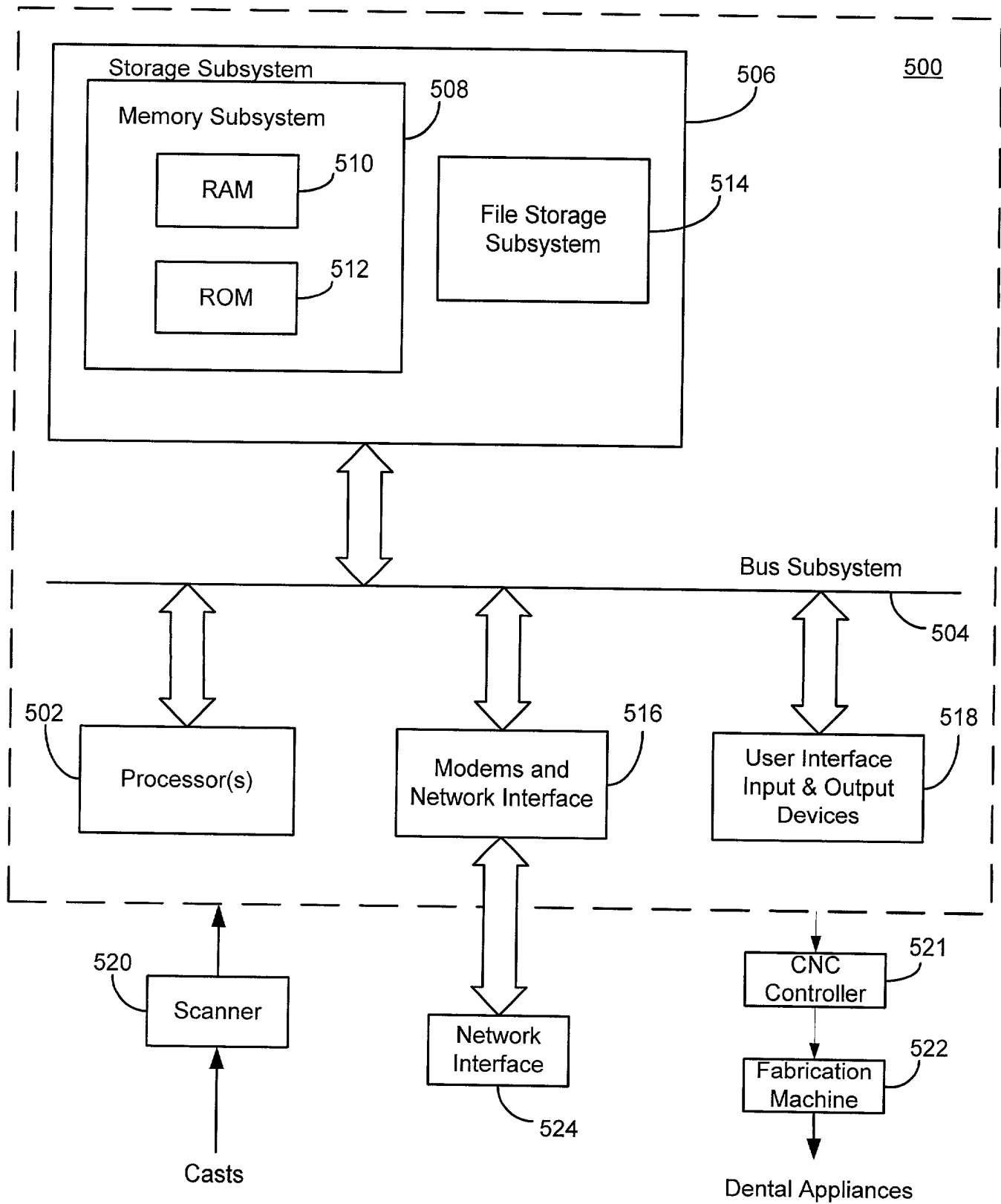


FIG. 7

COMBINED DECLARATION AND POWER OF ATTORNEY

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled SYSTEMS AND METHODS FOR MASS CUSTOMIZATION, the specification of which:

- ☒ is attached hereto.
☐ was filed on _____ as Application Serial No. _____.
☐ was described and claimed in PCT International Application No. _____ filed on _____ and as amended under PCT Article 19 on _____.

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose all information I know to be material to patentability in accordance with Title 37, Code of Federal Regulations, §1.56.

I hereby appoint the following attorneys and/or agents to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

Bao Q. Tran, Reg. No. 37,955
 James Heslin, Reg. No. 29,541

Hans R. Troesch, Reg. No. 36,950
 Richard A. Dunning, Jr., Reg. No. 42,502

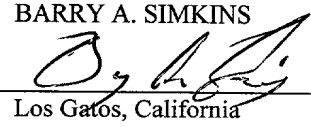
Address all telephone calls to Bao Q. Tran at telephone number 408.738.7243.

Address all correspondence to Bao Q. Tran at:

ALIGN TECHNOLOGY, INC.
 442 Potrero Avenue
 Sunnyvale, CA 94086

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patents issued thereon.

Full Name of Inventor: BARRY A. SIMKINS

Inventor's Signature: 

Residence Address:

Los Gatos, California

Citizenship:

United States

Post Office Address:

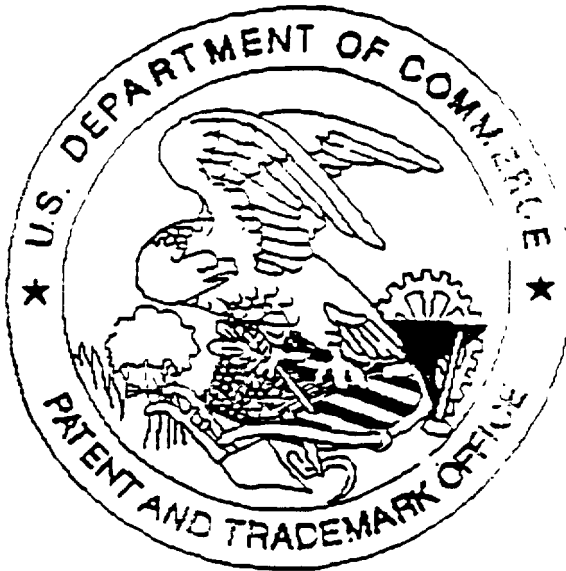
25450 Adams Road

Los Gatos, California 95030

Date:

7/20/00

United States Patent & Trademark Office
Office of Initial Patent Examination -- Scanning Division



Application deficiencies were found during scanning:

☐ Page(s) _____ of _____ were not present
for scanning. (Document title)

☐ Page(s) _____ of _____ were not present
for scanning. (Document title)

☒ Scanned copy is best available.

Drawings